

## ABSTRACT

A numerical value control system that controls a machine tool, by calculating a move command from a work program or a work data for a numerical value control unit, and directly inputting the move command to a servo control section (103) within the numerical value control unit (100) from the outside of the numerical value control unit (100). The numerical value control system comprises at the outside of the numerical value control unit: an analyzing unit (111) which analyzes a work program or a work data; and an interpolating unit (112) which carries out interpolation for each axis in a position control period of the servo control section based on output information from the analyzing unit (111) and cut conditions, whereby the numerical value control system controls a machine tool by directly inputting a move command of a binary format prepared in advance by the interpolating unit (112), to the servo control section (103) within the numerical value control unit (100).